

July-06-12 3:13:28 PM

Item ID: D2121

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 7/06/12 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 8/10/12 **Req'd Qty: 4.00**

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: 2-07-10 Tooling: Date:

Stop ***NR2***

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2121	Rev D

0.00

100

100

Large Fab

0.00

Large Fab

Memo

Large Fab

Weld washer & wing nut as per Dwg D2121 & QSI 004
-Identify as Wing Nut assembly

0.00

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

OC

Memo

Quality Control

0.00

120

Small Fab

0.00

120

Small Fab

Memo

Small Fab

Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121.
Drill and deburr hole in coupling nut as per Dwg D2121.
(Note: Install MS21042L4 Nut loosely)
Cut D2771-BCFC-025-150 at 1.500"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
24 10		20						

NOTE: Date & initial all entries

Work Order ID 86854

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86854

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Item ID: D2121

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 7/06/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description:

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: ST005

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

Smf
B917

4

4x

28

13-09-17

MCS B-09-17

MCS 13-09-17

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Picklist Print

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Work Order ID: 86854

Parent Item: D2121

Parent Item Name: Clamp

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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5/16-18 SS THREADED

Purchased

No

120

f

30.3700

0.541

4

FF

13-09-16

Threaded Rod 6.5" long

Location

Loc Qty

Loc Code

GA

30.37

121239

22.37

121486

2

122069

6

5/16-18 SS WING NUT

Purchased

No

100

Each

113.0000

1

4

12-8-29

Wing Nut

Location

Loc Qty

Loc Code

Mezz

113

110084

100

16016

13

5/16-18SS1COUPLING

Purchased

No

120

Each

10.0000

1

4

FF 13-09-16

Coupling Nut

Location

Loc Qty

Loc Code

Mezz

10

16016

10

5/16WC

Purchased

No

100

Each

1,694.0000

1

4

SS Flat Washer 5/16 FW516S1

Location

Loc Qty

Loc Code

ST377

1674

120262

1674

ST522

20

120208

20

NIA
AA

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Work Order ID: 86854

Parent Item: D2121

Parent Item Name: Clamp

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

5/16WC Purchased No

120 Each 1,694.0000 1 4

SS Flat Washer 5/16 FW516S1

EL 12-8-29

Location Loc Qty Loc Code

ST377 1674

1674

120262

4

ST522 20

20

120208

AN4-4A Purchased No

120 Each 50.0000 1 4

Bolt

FF 13-09-16

Location Loc Qty Loc Code

FP001 125709 6

6

114615

4

ST355 44

31

120187

121285 13

AN960JD416 NAS1149D0463J Purchased No

120 Each 29.0000 1 4

Washer

FF 13-09-16

Location Loc Qty Loc Code

ST351 126221 29

8

116289

119097 21

4

D2012-107 Manufactured No

120 Each 26.0000 1 4

Clevis

FF 13-09-16

Location Loc Qty Loc Code

ST 108246 6

6

82039

4

WA005 20

20

85862

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Shop Packet Print

Page 2

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Page 3

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Parent Item: D2121

Parent Item Name: Clamp

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 4.00

Required Qty: 4.00

D2529
Washer

Manufactured No

120 Each 539.0000

5 M 20 FF 13-09-16

Location

Loc Qty

Loc Code

ST010

539

79485

18

81873

21

84435

500

12+8

D2771-BCFC-025-150
Bolt

Manufactured No

120 Each 712.0000

1 4

FF 13-09-16

Location

Loc Qty

Loc Code

Mezz

712

8754

712

4

D2771-LCC-025
Lock Nut

Manufactured No

120 Each 697.0000

1 4

FF 13-09-16

Location

Loc Qty

Loc Code

Mezz

697

4554

6

8493

691

4

MS21042L4
Nut

Purchased No

120 Each 1,401.0000

1 4

FF 13-09-16

Location

Loc Qty

Loc Code

ST300

1401

119075

116

121011

193

121444

792

121652

300

4

4

FF 13-09-16

5/16-18 Jamnut

m110084

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PD 12-07-10
54

5/16-18 WINGNUT


5/16 - 18 THREADED ROD
6.5 LONG

5/16 -18 JAMNUT

STAINLESS STEEL
5/16-18 1" COUPLING NUT
D2012-107 CLEVIS

AN4-4A BOLT
AN960JD416 WASHER
MS21042L4 NUT, INSTALL LOOSE

DRILL THRU $\frac{1}{4}$ (.250) DIA

D2529 SS WASHER (5)*  -

D2771-LCC-025 SS LOCK NUT (1)*

*OR EQUIVALENT

RELEASED
04-05-04

D	C	B	I	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
1	2	3	4	DRAWN		BASIC CODE	DIA. DASH NO. H-HEAD REAR SIDE H-HEAD FEAR SIDE	CONTRACT NO.	DART • DART AERO ACCESSORIES INC. VANCOUVER CANADA				
5	6	7	8	APPROVED		C-DIMPLE D-DIM NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. H-SPOTWELD	DRAWN					
DESCRIPTION					REQUIREMENTS — UNLESS OTHERWISE SPECIFIED	BASIC CODES		DESIGN	TITLE CLAMP, BATTERY				
OF					GENERAL	TOLERANCES —	BLMMS20470AD B-MMS20470AD	STRESS					
CHANGE					LIMITS		CHECKED						
1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125/ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 8 — 7747 5. HOLES PER AND 10387					1. TOLERANCES — .X08 & .030 2. ANGLES 1/4° 3. PARALLELISM 1/1000 4. ECCENTRICITY 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	CLIENT		CODE	DWG NO	REV			
REPORT ALL DISCREPANCIES — DO NOT SCALE									SCALE	SHT	OF		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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